



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-023

Job Sheet 168619



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/30/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Abu Dhabi Aviation (CABUD01)

PO Box 2723, Abu Dhabi International Airport Abu Dhabi, 2723 United Arab Emirates ph:971 2 575 8000
fx:971 2 575 7775.

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run hrs Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/29/17	11/29/17	0.00 0.00	Start Up Skidtubes		
100	Skid tubes	1 pcs	11/29/17	11/29/17	0.88 2.11	Skid tubes		AP 2017/12/12
110	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		17-12-15-24
120	HandFinish	1 pcs	11/29/17	11/29/17	0.00 0.38	HandFinish1		DEB 17/12/16
130	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC7		JW
140	Skid tubes	1 pcs	11/29/17	11/29/17	0.00 2.11	Skid tubes		AP 2017-12-18
150	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		BE
160	Skid tubes	1 pcs	11/29/17	11/29/17	0.00 2.11	Skid tubes		BE
170	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC10		PD
180	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC5		AP 17-12-21
185	HandFinish	1 pcs	11/29/17	11/29/17	0.00 0.38	HandFinish2		2017-12-21
191	Spray Paint	1 pcs	11/29/17	11/29/17	0.00 0.91	Spray Paint	PO038670	252
200	QC	1 pcs	11/29/17	11/29/17	0.00 0.00	QC14		17-12-21
230	HandFinish	1 pcs	11/30/17	11/30/17	0.00 0.38	HandFinish4		18-01-06
240	QC	1 pcs	11/30/17	11/30/17	0.00 0.00	QC5		18-1-9
250	Packaging	1 pcs	11/30/17	11/30/17	0.00 0.00	Packaging3		18-01-09
260	QC21-SA	1 Ea	11/30/17	11/30/17	0.00 0.00	QC21	FG 083	JAN 04 2018

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of
skid tube as per Dwg D3391 6-Deburr, scibe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view
F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149
locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer
drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
BATCH: 5017267 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
drill remaining 6 wearplte holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
section G-G to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to



S020586



Mid Tube Assembly

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Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:
Revision:
Operation:
Change No:

D3391-023

Start up Operation

Mfg Date: 12/12/17
Job No: 168619

Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe

140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 2018/04/21 batch#: M138654

NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE

160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush

185 - Re-alodine

191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: _____

230 - 1-Install Inserts as per Dwg

Job Allocations

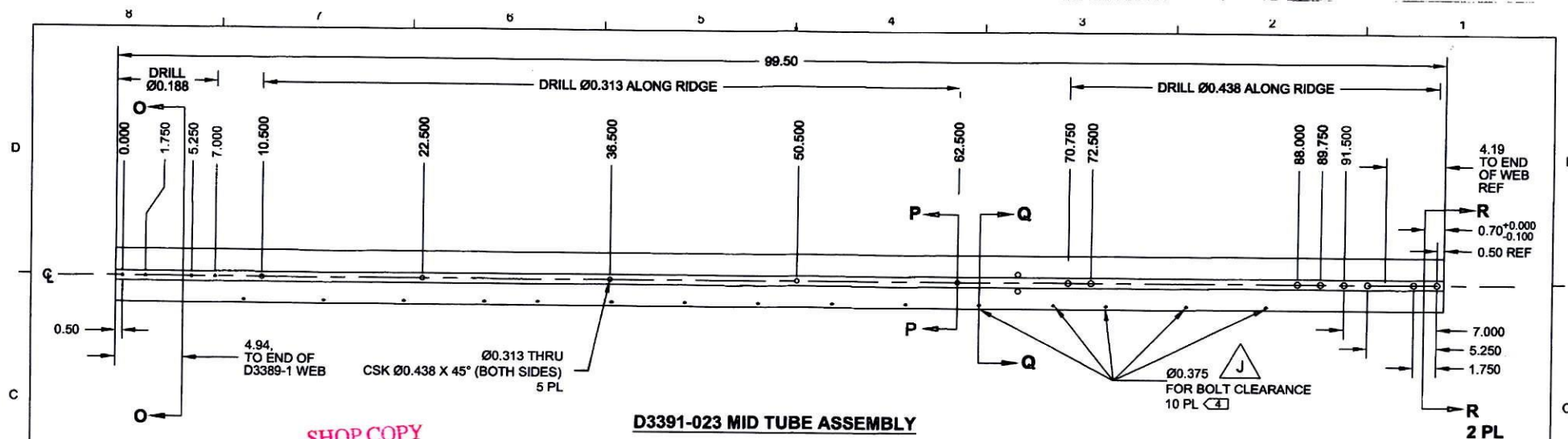
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-1-100 163253	1	92	0	0
140-Skidtubes	D3389-1 8018928	1	8	0	0
160-Skidtubes	D3681-1 5019147	5	111	0	0
230-HandFinish	ALS4-1032-130 500727	20	12,374	0	0
	D3591-1 5019103	2	85	0	0

Part Specifications

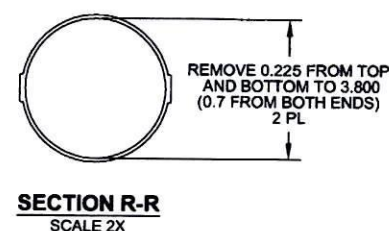
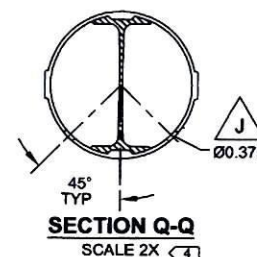
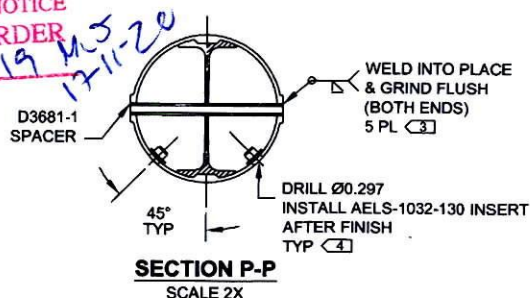
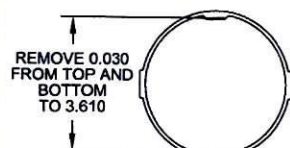
Specifications could not be found.

Plex 11/20/17 10:15 AM dart.lacelle.linda

501 207



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168619 M.S. 17-11-20



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
2016-04-28

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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